Qty:

: STRUT

: D219923

: N/A

: NW

: 11/25/2006

; E1

: D2199 REV. E1

Thursday, 11/9/2006 4:37:09 PM

Kim Johnston User:

Process Sheet

Drawing Name

Part Number

Material

Due Date

Drawing Number

Project Number

Drawing Revision

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 29387

Estimate Number

: 10219

P.O. Number

· NIA

This Issue

Prsht Rev.

First Issue

: 11/9/2006

: W/M :NIA

Previous Run Written By

Checked & Approved By

Comment

S.O. No. : NIA

: Est:D

Type

Rem polish & add finishNG/CC

: SMALL /MED FAB

Additional Product

Job Number:



Seq. #:

Description:

M304TR0750W049 1.0

304 RD Tube .750 x .049W

Comment: Qty.: 2.3100 f(s)/Unit Total:

Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall

(M304TR0750W049)

Batch No: M 132 373

NC BRAKE

10 Um:

Each

2.0

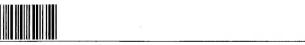
4.0

BRAKE NC

Comment: BRAKE NC

Punch per Dwg D2199 and Spec Control Dwg D2638

3.0 SMALL FAB SMALL & MEDIUM FAB RESOURCE 1



23.1000 f(s)



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

INSPECT WORK TO CURRENT STEP



QC5



Comment: INSPECT WORK TO CURRENT STEP

5.0 POWDER COATING POWDER COATING



Comment: POWDER COATING





6.0

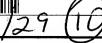
Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3





Comment: INSPECT POWDER COAT





Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES										
DATE STEP		PROCEDURE CHANGE					Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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		4			100							
		3					J	l				

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA: 🕰) Date: <u>0 7/01(0</u> ス
			QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
	T	Description of NC		Corrective Action Section B		Verification	A			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approva QC Inspecto		
		w. See								
	- 1 -									
			+							
				· · · · · · · · · · · · · · · · · · ·			·	-		
		*		4						

NOTE: Date & initial all entries

Date: User: Thursday, 11/9/2006 4:37:09 PM

* Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 29387

Part Number: D219923

Job Number:



Seq. #:

Machine Or Operation:

Description:

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location: <u>5122</u>2

8.0



QC21

Comment: FINAL INSPECTION/W/O RELEASE



Job Completion



Dart Aerospace Ltd

W/O:	4	WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
Dort No.		DAD # . Foult Cotomon	NOD- V			D-4	L.,,,,,				

Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
			QA: N/C	closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	A			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	ription Sign & Date		Approval Chief Eng	Approval QC Inspector		
*		V 2	2				:			
(4)										
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*	,	191								

NOTE: Date & initial all entries





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Α	98.04.28	DATE		CHECKED	Con	- F
1993		7	+	ASPROVED	ORAWN BY	
NEW ISSUE	STRUT DETAILS	JULE	D2199 SHEE	DRAWING NO.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	

C 0

ADDED ADDED

AND

-21 17 ADDED

AND. 19

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98.04.28

ADDED -23 AND ADDED TEMPLATE REDRAWN IN CAD

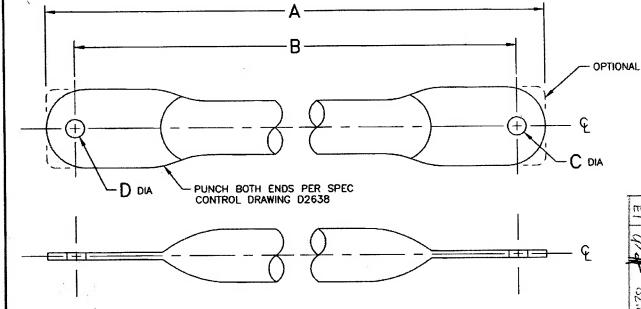
-25 PER & SPEC (

CTRL

A565M DWG

02.03.22

ADD FINISH



		Α	В	C	D.
	D2199-1	18.30	17.50	0.257	0.257
	D2199-3	5.80	5.00	0.257	0.257
	D2199-5	22.64	21.84	0.257	0.316
	D2199-7	14.74	13.94	0.257	0.257
	D2199-9	16.52	15.72	0.257	0.257
	D2199-11	23.60	22.80	0.257	0.316
2 2	D2199-13	15.96	15.16	0.257	0.257
B C	D2199-15	17.57	16.77	0.257	0.257
	02199-17	28.05	27.25	0.257	0.316
SHOP COPY RETURN TO RETURN TO ENGINEERING ENGINEERING UNCONTROLLED SUBJECT TO AMENT	D2199-19	.18.90	18.10	0.257	0.257
TO ROTE	D2199-21	10.80	10.00	0.257	0.257
	D2199-23	26.18	25.38	0.257	0.316
角田母さ	D2199-25	19.93	19.13	0.257	0.257
	D2199-27	27.34	26.54	0.257	0.316
ž O	82199-29	21.11	20.31	0.257	0.257
COPY RN TO EERING LLED COPY AMENDMENT	D2199-29	21.11	20.31	0.257	0.257

-00.10.13 ip 00.10.13

NOTES:

1. MAKE PER TEMPLATE DT2199-XX WHERE XX IS THE RESPECTIVE DASH NUMBER
2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE \$0.750 x 0.049 WALL
3. FINISH: POWDER COAT WHITE (43.5.Z) PER DART Q51 005 43/EX

WITHOUT NOTICE
WORK ORDER

1 0 SCALE NTS

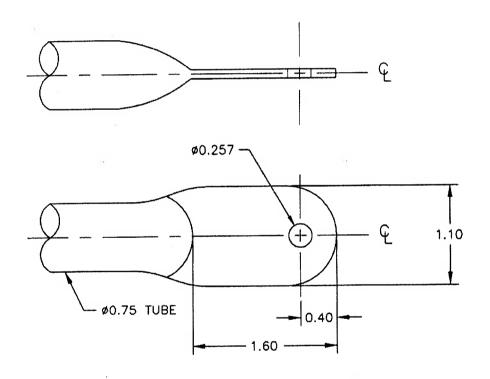




DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. REV	/. A
MA	14	D2638 SHEET 1 0	F 1
DATE		TITLE SC	ALE
98.04.28		PUNCH DT8117 SPEC CONTROL	1:1
Α	98.04.28	NEW ISSUE	



SPECIFICATION CONTROL DRAWING FOR PUNCH DT8117



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

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